






Annex 1

Digital light Processing (DLP) printer, operation software and parameter

Model (Picture)	Printer Manufacturer	Light source	Light intensity	Operation Software	Parameter data set*
	Asiga Max	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_dx rapid cast 2.0_5
	Asiga Max 2	385 nm	7.0 mW/cm ²	Composer 2.0.8	Detax_dx rapid cast 2.0_5
	Asiga PRO 4K	385 nm	7.0 mW/cm ²	Composer 1.2.11	Detax_dx rapid cast 2.0_5
	Asiga Ultra	385 nm	6.6 mW/cm ²	Composer 2.0.8	Detax_dx rapid cast 2.0_5
	Rapidshape HA20+/HA30+ HA40+/HA50+	385 nm	2.0 mW/cm ²	Netfabb 2020	DETAX dx rapid cast 2.0

*The set of parameters includes all relevant material- and printer specific information

Cleaning Equipment

Cleaning unit Manufacturer, Model	Cleaning process
Rapidshape RS wash	Use the following settings: DETAX dx rapid cast 2.0 Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air (max. 2 bar).
Ultrasonic bath Bandelin Sonorex	Clean the parts with isopropyl alcohol (purity $\geq 98\%$) for 2 minutes. Then thoroughly clean the openings, cavities and gap areas with compressed air (max. 2 bar). The main cleaning is performed in a separate vessel with fresh isopropyl alcohol (purity $\geq 98\%$) for 2 minutes. Prior to post-exposure, check the openings, cavities and gap areas for residues. Then blow off with compressed air (max. 2 bar). After washing and before post-curing, it's necessary to let the cast molds rest at room temperature for a minimum of 15 minutes.

Light curing Equipment

Light Curing unit Manufacturer, Model	Curing process
NK Optik Otofash G171	2 × 2000 flashes under inert gas, turn around components after 1000 flashes
NK Optik Otofash 250/500	4000 flashes under inert gas @15 Hz
Rapidshape RS cure	Use the following settings: DETAX dx rapid cast 2.0



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